Work Orde September-27-13		66		*107	7566*						Page 1
Revision ID:	D3926-1 Wedge		· A	Accept	*N900	<b>040</b>	100	<b>)</b> *	Setup Sta	1/1	S1* S2*
Start Date: Required Date: Reference:		start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					
Approvals:	Process Plan: QC:	•	Date: 13 09-30	Tooling: SPC (Y/N):		ate:		1	Run Sta Sto		R1* R2*
Sequence ID/ Work Center II		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3926	Rev A										
*100				0.00				lo			Jm 13-10-09
Waterjet FLOW CNC Waterje  HIMM 1"	et	Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if		0.00							
110	Ç	C2- Inspect parts off n	nachine FAI/FAIB	0.00				(-	_		To 13-10-0

0.00

Memo

Quality Control

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NCR:	Yes ,	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE					
<u> </u>											QA	Closed:	Dat	te:	
Work Ord	eř.					DISPOSITION				AGAINST D	EPAR	TMENT/	PROCESS		
Work Orac						Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part I	No.					Scrap			Machining	Small Fab		Proc	d. Eng. Coor.		Quality
	_					Use-as-is	1 !	1	noforming	Finishing	<b>−</b>		e/Packaging		Other
NCR I	No					Work Order Update	]		Large Fab	Composite			Supplier		
Root						ption of work order update	1	Initial		tion	Si	ign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
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		Cuffs	pcu			Contamination	$\vdash$	Mainte		-	⊣	Moved		ш	The state of the s
	-	leat Trea	t .			Countersink	$\vdash$	Mislabe		-	┥	itioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ord</b> September-27-1.	,			*107	756	66*				APPA 18 30 30 30 30 30 30 30 30 30 30 30 30 30			Page 2	2
Item ID: Revision ID: Item Name:	D3926-1 Wedge			Accept	*N	1900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	9/24/13 9/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item II Customer:	D:	_		D	Staut			
Approvals:	Process P	an:	Date:	Tooling:		Da	te:			Run	Start Stop	*N	R1*	
	QC:		Date:	<b>SPC (Y/N):</b>		Da	te:				Stop	*NI	R2*	
Sequence ID/ Work Center II	<b>D</b>	Operation Description	·	Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Re Qt		Reject Number	Insp. Stamp	
120		QC8- Inspect parts - seco	ond check	0.00					6					
*120* QC Quality Control		Memo		0.00 <b>27</b> 9-89 12-10	)				<u> </u>					
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Quality Control

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NCR: Yes	s / No			WORK ORDER NON	-CONFORI	MANCE / UF	DATE	QA Closed:	Date:	
Work Order:				DISPOSITION	İ		AGAINST DE	PARTMENT	/PROCESS	
Part No.				Rework Scrap Use-as-is Work Order Update	<del>_</del>	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		<u> </u>		Description of work order update	Initial	A	ction	Sign &		
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Landing	g Gear	General	 _	 _	_
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
Ţ	Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
ſ	Wave/Twist in Tube	Folio	Outside Dimensions		

**FAULT CATEGORY** 

Unapproved

Work Ordenseptember-27-1				*107	7566*							Page 3
Item ID: Revision ID: Item Name:	D3926-1 Wedge			Accept	*N900	<b>040</b>	100	)* 5	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	9/24/13 9/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:	D:						
Approvals:	Process P	Plan:	Date:	Tooling:		ite:		I	Run	Start Stop		R1* R2*
Sequence ID/ Work Center I 150 *150* Packaging	D	Operation Description Identify as per dwg & St	lock Location	Set Up/ Run Hours  0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp  DAS  26 9-89
Packaging		OC21- Final Inspection	- Work Order Release	0.00			ıΛ	1	)	,	13	-109

0.00

Memo.

\*160\*

Quality Control

110/10

13-10-10

							•				DQA:	Date	:
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						<u> </u>	1				QA Closed.	Date	•
Work Orde	٠ <u>٠</u> ٠					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	-''-			· · · · · · · · · · · · · · · · · · ·		Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR N	lo.					Work Order Update	1	î	Large Fab	Composite	·	Supplier	1
							1						
Root					Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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						<del></del>	AUL	T CATE	GORY				
Landii					_	General	_	1		_	1	_	٦ .
	$\vdash$	Bending				Bend	_	Grain			Ovalized	<u> </u>	Pressure/Forced
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	$\boldsymbol{\vdash}$	Crushed/	Crimped			Burrs		Í	ions Incomplete/	<b>)</b>	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination	<u> </u>	Mainte		<b>⊢</b>	Part Moved		
	⊢	Heat Trea			<u> </u>	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V		7
·	$\boldsymbol{\vdash}$	Inspection	•	Tube	-  _	Cut Too Short	<u></u>	Misread			Power Loss/	Surge	Other
	${f}$	Ripples in			ļ	Drill Holes		Offset					
	l l	Torque W	aves in E	xtrusio	n [	Drawing	1	Out of C	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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## **Picklist Print**

September-27-13 12:48:18 PM

Work Order ID:

107566

Parent Item:

D3926-1

Parent Item Name:

Wedge

**Start Date:** 9/24/13

Required Date: 9/27/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP RevA: New issue DD verified by:EC

Comments:	III KCVA. New 133	uc DD termed e	,										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No		*****	100	sf	1,000.6282	0.3609	-2 <del>.279368</del> 4 - 2.5	<b>V</b>	J	m3-10-C
				<u>Location</u>		Loc Qty	<u>Lo</u>	oc Code				•	
,				MAT019		1000.628179							
				121	278	9.62817947							
				122	2575	47.6							-
				123	3229	53							
				123	3704	63.8							
				123	3949	6.96							
				124	1382	197.12							
				124	1758	17.52							
				125	5137	205							
				m1	26748	400			190	8 PF 2			

				•					DQA:	Date:	
NCR: Yes	s / No	•			WORK ORDER NON-	CONFOR	MANCE / UF	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION	i		AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update	<b>⊣ I</b>	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T			Descri	otion of work order update	Initial	A	ction	Sign &		
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Unapproved	7										
						AULT CATE	GORY				

Positioned Wrong Heat Treat Countersink Mislabeled Other Misread Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence Folio Wave/Twist in Tube **Outside Dimensions** 

Grain

Hardware

Maintenance

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Broken/Damaged

**Landing Gear** 

Bending

Cracks

Cuffs

Crushed/Crimped

Centre Not Concentric to O/S

DART AEROSPACE LTD	Work Order:	107566
Description: Wedge	Part Number:	D3926-1
Inspection Dwg: D3926 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1:8 <del>3</del>	-		V	JAMO1
1.50	+/-0.030	1.494"	_		V	
1.50	+/-0.030	1.484	-		V	
1.75	+/-0.030	1.747	-		V	
2.00	+/-0.030	2.001	-		V	
2.92	+/-0.030	2.912"	_		V	
1.00	+/-0.030	1.00"	•		V	
0.25	+/-0.030	0.26."	<u>-</u>		V	
0.25	+/-0.030	0.257	_		11	
3.71	+/-0.030	3.71"	_		V	
1.00	+/-0.030	1.004	_		J	
14.01	+/-0.030	14.01"	_		7	JAMOG
						· -
			-			
		· <b>c</b>	AS	-		

	<u> </u>			
Measured by: JM	Audited by:	9-89	Prototype Approval:	N/A
Date: 13-10.09	Date:	BRG	Date:	N/A

Rev	Date	Change	Revised by	Approved
_ A	09.09.17	New Issue	KJ KJ	1//
			——————————————————————————————————————	74

		DQA:	Date:	
NCP: Vos / No	WORK ORDER NON-CONFORMANCE / LIPDATE			

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Skid-tube Crosstube Water Jet Engineering Rework Small Fab Prod. Eng. Coor. Quality Scrap Machining Part No. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Action Sign & Initial Root Verification or Non-conformance Chief Eng Description Date QC Inspector Date Step Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bending Bend Grain Ovalized Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Maintenance Contamination

	neat neat	Countershik	- Iviisiabelea	
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
	Ripples in Bend	Drill Holes	Offset	
[	Torque Waves in Extrusion	Drawing	Out of Calibration	
	Turning Sequence	Finish	Out of Sequence	
	Wave/Twist in Tube	Folio	Outside Dimensions	
11. /FODNAC /O	ality Assurance and CA (NCR)MO Boy C		·	

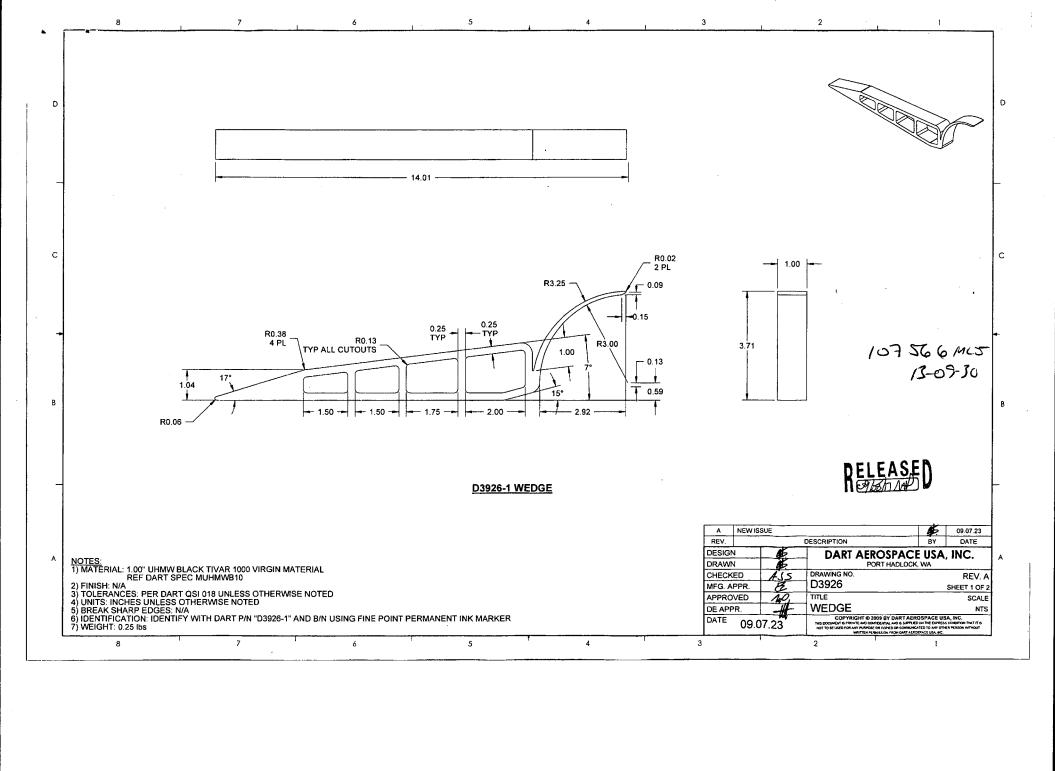
Mislabeled

Countersink

Positioned Wrong

**Heat Treat** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



											DQA:	Dat	te:		
NCR: Y	es / No				WORK ORDER NON-CONFORMANCE / UPDATE						A Closed:	 Da	ta·		
											·		ie.		
Work Order:					DISPOSITION			AGAINST DEPARTMENT/PROCESS							
Part N			***************************************		Rework Scrap Use-as-is	Scrap Machining Small Fab			Water Jet Prod. Eng. Coor. Rec/Store/Packaging				Engineering Quality Other		
NCR N	lo				Work Order Update	]		Large Fab	Composite	]		Supplier			
Root				Descri	ption of work order update		Initial Action			Τ	Sign &				
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	iption	$oxed{oxed}$	Date	Verification	n	QC Inspector	
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[	Bending				Bend		Grain			Jo	valized			Pressure/Forced	
	Centre I	Not Conce	ntric to	o/s	BOM/Route		Hardware			]0	ver/Under	tolerance		Temperature/Cure	
	Cracks				Broken/Damaged		Inspecti	on incomplete		]Pi	art Incorrec	t l		Weld	
	Crushed	l/Crimped			Burrs		Instructi	ions Incomplete/U	Inclear	Pi	art Lost/Mis	ssing		Wrong Stock Pulled	
	Cuffs				Contamination	Г	Mainte	nance		Pi	art Moved	•		<del>-</del>	
	Heat Tr	eat			Countersink		Mislabe	led		Pr	ositioned W	/rong		_	
	Inspecti	on Strip ir	Tube		Cut Too Short		Misread	l		Pr	ower Loss/S	Surge		Other	
	Ripples in Bend Drill Holes						Offset					•			

Out of Calibration
Out of Sequence

Outside Dimensions

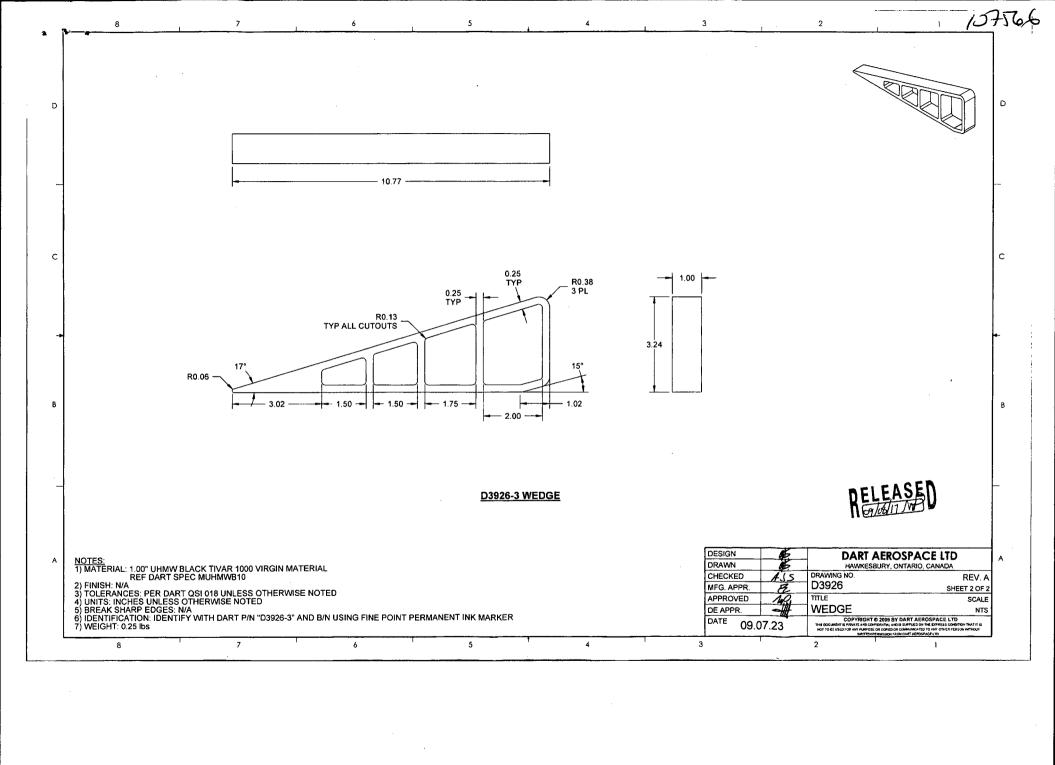
Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio



										DQA:	Date:			
NCR: Y	es / No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE					
· · · · · · · · · · · · · · · · · · ·							_	tu:		QA Closed:	Date:			
Work Orde	or.				DISPOSITION AGAINST D					DEPARTMENT/PROCESS				
				<del></del>	Rework	Skid-tube Crosstube				Water Jet	Engineering			
Part N	lo				Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	Thermoforming Finishing			Finishing	Rec/Sto	re/Packaging	Other		
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier			
Root		T	1	Descri	ption of work order update	Γ.	Initial	Act	ion	Sign &	<u> </u>	<u> </u>		
Cause	Date	Step	Qty		or Non-conformance	1	nief Eng		iption	Date	Verification	QC Inspector		
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Landir	ng Gear				General		_			_		_		
[	Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorre	ct	Weld		
	Crushed/	'Crimped			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs	:			Contamination		Mainte	nance		Part Moved				
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	Wrong	•		
	Inspection	n Strip in	Tube	1	Cut Too Short	Misread				Power Loss/	'Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

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